

Date: Thursday, 9/20/2007 3:27:01 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 34743		
Estimate Number	: 12984		
P.O. Number	: N/A	Part Number	: D36201
This Issue	: 9/20/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3620 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 33873	Drawing Revision	: A
Written By	:	Material	: N/A
Checked & Approved By	:	Due Date	: 10/3/2007
Comment	: Est A 07.08.09 new issue EC verified by:JLM	Qty:	30
Um:	Each		

Additional Product

Job Number:



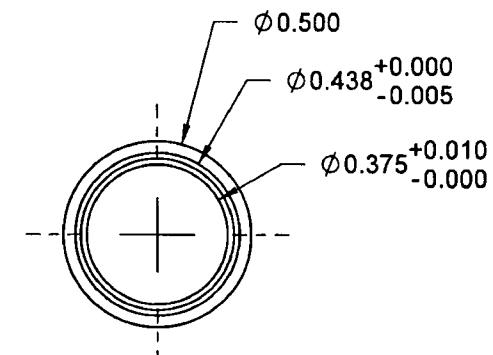
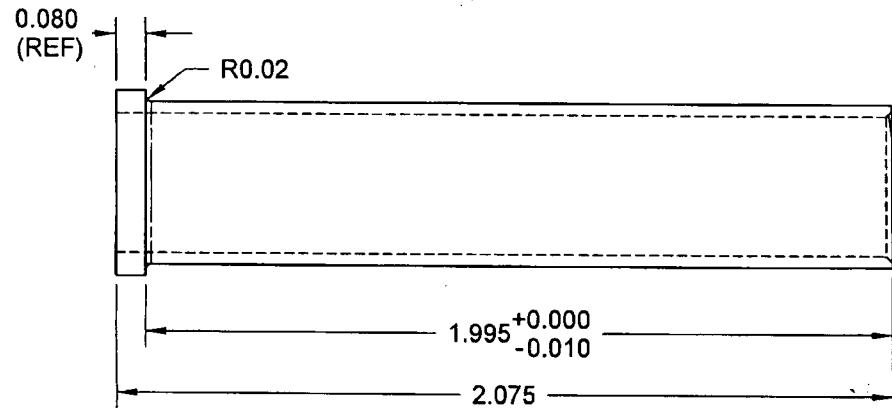
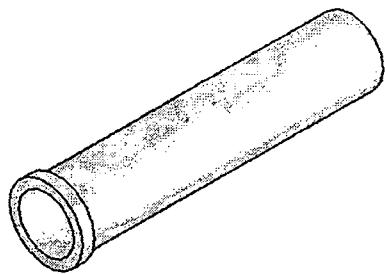
Seq. #:	Machine Or Operation:	Description :
1.0	M303R0625	303 Round Bar 0.625"
		 Comment: Qty.: 0.1943 f(s)/Unit Total : 5.8275 f(s) Material: Ø0.625 AISI 303 SS Rod (M303R0625) Batch: 10405267 24 07/09/24 m 15267 5.6
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		 Comment: HARDINGE CNC LATHE SMALL Machine as per folio FA703 Deburr and tumble
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 24 07/09/24
4.0	QC8	SECOND CHECK
		 Comment: SECOND CHECK J.F. 07/09/24 (31)
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST 110 25 (31)
6.0	QC21	FINAL INSPECTION/W/O RELEASE
		 Comment: FINAL INSPECTION/W/O RELEASE 12 07/09/05 (31)
Job Completion		 Comment: Job Completion 11 07.09.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/09/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3620-1 BUSHING

RELEASED
07.07.19

NO. 34743
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND TUBING
(REF DART SPEC M304TR) OR
AISI 303 STAINLESS STEEL ROUND BAR
(REF DART SPEC M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3620-1" USING FINE POINT
PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

A	NEW ISSUE		CB	07.07.19
REV.	DESCRIPTION		BY	DATE
DESIGN	C.B.	DART AEROSPACE LTD		
DRAWN	C.B.	HAWKESBURY, ONTARIO, CANADA		
CHECKED	C.E.	DRAWING NO.	REV. A	
MFG. APPR.	E.P.	D3620	SHEET 1 OF 1	
APPROVED	#	TITLE	SCALE	
DE APPR.	#	BUSHING	2:1	
DATE	07.07.19		COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD	Work Order:	
Description: Crosstube Assembly	Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.075	+/- .010	2.075			
	1.995	- .010	1.989			
	.080	+/- .010	.084			
	R.020	+/- .020	R.020			
	.500	+/- .010	.500			
	.438	- .005	.435			
	.375	+ .010	.377			
SIDE B						

Measured by:	<i>RP</i>	Audited by:	<i>S.F</i>	Prototype Approval:	N/A
Date:	07/09/24	Date:	07/09/24	Date:	N/A
Rev	Date	Change		Revised by	Approved
A		New Issue		KJ/JLM	